



Dart Aerospace Ltd.
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K6A 1K7
Canada

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RBW6305G19631-3G-23
Job Sheet 198011



Part No: RBW6305G19631-3G-23

Job Qty: 1 pcs *4 MLL*

Part Name: Inside Placard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 8/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G19631-3G Rev 3 IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	8/23/19		0.00	0.41	Small Fab - 1		
							Small Fab - 2		<i>MLL</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	8/23/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	8/23/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S204064



Part: RBW6305G19631-3G-23

Job No: 198011

Serial No/Batch: S204064

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/08/19

DAS
81
9-89

AUG 08 2019

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MCC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
140	QC 21 - SA	1 pcs	8/23/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - (Small Fab) 1-Engrave placard using Laser engraver as per DWG. Sheet 4. ***NOTE*** Use PDF
 Descriptions: 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
LM922402	Plastic, Black & White	.2340 sf (.234 ea)	110-Small Fab - 1	5151069

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	LM922402	0	78	0

Part Specifications

Specifications could not be found.

Plex 7/19/19 1:42 PM Dart.lajeunesse.marie

RBW6305G19631-3G

ITEM	TOOL NUMBER	DESCRIPTION	QTY.
1	RBW6305G17131-3G	TOOL, PUMP 1-2-3 DRIVE QUILL SEAL HOUSING REMOVER	1
2	RBW6305G17931-3G	TOOL, PUMP 1-2-3 DRIVE QUILL LIP SEAL INSTALLER	1
3	RBW6305G17631-3G	TOOL, PUMP 1-2-3 DRIVE QUILL LIP SEAL REMOVER	1
4	RBW6305G18251-3G	GUIDE, PUMPS/ECS DRIVE QUILL SEAL HOUSING INSTALLER	1
5	RBW6305G14331-3G	TOOL, UPPER MODULE LIP SEAL INSTALLER	1
6	RBW6305G14031-3G	TOOL, UPPER MODULE LIP SEAL INSTALLER	1
7	RBW6305G13231-3G	TOOL, GIMBAL CARBON SEAL INSTALLER	1
8	RBW6305G13731-3G	TOOL, GIMBAL CARBON SEAL REMOVER	1

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 198011 MCJ
1907-22

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED MISSING TOOL NUMBER & ITEM NUMBERS TO -23 PER RW.	5/9/2011	RJC	RW
2A		-23 CH'D DESCRIPTIONS, WAS BUYOUT IS MANUFACTURED.	10/30/2013	CFS	RJC
3	17-0138	-23 CH'D DIM WAS 5.50 IS 5.00, WAS R.37 (x4) IS 4X R.13. CH'D TOLERANCE WAS .XXX ±.005 .XX ±.01 IS .XXX ±.010 XX ±.03. ADDED USE PDF NOTE. DELETED TEXT ARIAL, 3/16 LETTERS (x4), ARIAL, 1/8 LETTERS.	6/13/2017	RJC	JAG

4X R.13

BLACK BACKGROUND WITH WHITE LETTERS

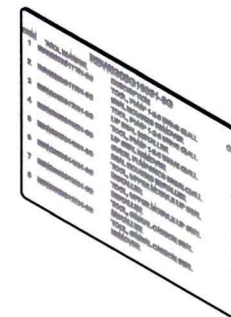
RBW6305G19631-3G			
ITEM	TOOL NUMBER	DESCRIPTION	QTY.
1	RBW6305G17131-3G	TOOL, PUMP 1-2-3 DRIVE QUILL SEAL HOUSING REMOVER	1
2	RBW6305G17831-3G	TOOL, PUMP 1-2-3 DRIVE QUILL LIP SEAL INSTALLER	1
3	RBW6305G17831-3G	TOOL, PUMP 1-2-3 DRIVE QUILL LIP SEAL REMOVER	1
4	RBW6305G18251-3G	GUIDE, PUMPS/ECS DRIVE QUILL SEAL HOUSING INSTALLER	1
5	RBW6305G14331-3G	TOOL, UPPER MODULE LIP SEAL INSTALLER	1
6	RBW6305G14031-3G	TOOL, UPPER MODULE LIP SEAL INSTALLER	1
7	RBW6305G13231-3G	TOOL, GIMBAL CARBON SEAL INSTALLER	1
8	RBW6305G13731-3G	TOOL, GIMBAL CARBON SEAL REMOVER	1

5.00

6.75

.06

NOTE:
USE PDF.



(-23)

INSIDE PLACARD

DART AEROSPACE	
TITLE MAIN ROTOR DRIVE TOOL KIT 1	
DWG NO. RBW6305G19631-3G-23	REV 3
MAT'L PLASTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ±1°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: RJC 06/13/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/14/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/07/2017	AW139
SCALE 1:2	DATE 6/13/2017 SHEET 4 OF 5